

98089

Tuesday, March 05, 2013 1:52:38 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

40

40

Reference:

Run Start *NR1*

Date:

Stop *NR2*

Date:

**Insp.
Stamp**

Rev A

0.00

100

Hardinge CNC LATHE SMALL

0.00

Hardinge

Hardinge CNC Lathe Small

Memo

Hardinge CNC LATHE SMALL
Turn per Folio FA727 and Dwg D3759

DO NOT Debur ENDs

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

Quality Control

13.3.24

40

4

DAS
04
9-89

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION <div style="display: flex; justify-content: space-around;"> <div style="text-align: right;"> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> </div> <div style="text-align: right;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div style="text-align: right;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div style="text-align: right;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div style="text-align: right;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>								
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Doc/Data												
Equip/Tooling												
Operator												
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Training												
Unapproved												
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Work Order ID 98089***98089***

Page 2

Tuesday, March 05, 2013 1:52:38 PM

Item ID: D3759-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 3/5/2013 Start Qty: 40.00

40

Cust Item ID:

Required Date: 3/19/2013 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

40x *SL* 13-03-26

13/3/27 *[Signature]*

MLJ 13-03-26

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, March 05, 2013 1:52:44 PM

Page 1

Work Order ID: 98089

98089

Parent Item: D3759-1

D3759-1

Parent Item Name: Bushing

Start Date: 3/5/2013

Required Date: 3/19/2013

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 08-03-04 new issue DD verified by: LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			110	f	83.5250	0.0725	3.052632			

M304R0 375

304 ROUND BAR 0.375

**

PO 13/03/23

Location

Loc Qty

Loc Code

MAT029

83.525

119346

2.328

120204

5.442

121380

3.846

→

123294

71.909

3.06

NCR: Yes / No

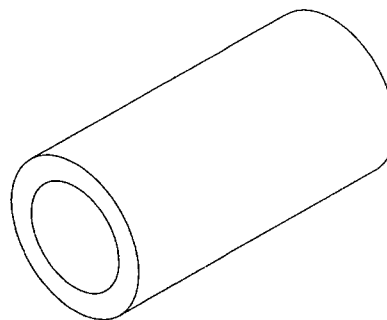
WORK ORDER NON-CONFORMANCE / UPDATE

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Other												
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Supplier												
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FAULT CATEGORY										
Landing Gear			General							
<input type="checkbox"/> Bending	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Cracks	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Wave/Twist in Tube
<input type="checkbox"/> Bend	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Burrs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Countersink	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Drawing	<input type="checkbox"/> Finish	<input type="checkbox"/> Folio
<input type="checkbox"/> Grain	<input type="checkbox"/> Hardware	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Misread	<input type="checkbox"/> Offset	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions
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							<input type="checkbox"/> Other			



D3759-1 BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROD
(REF. DART SPEC M304R)
OR AISI 304/316, STAINLESS STEEL TUBE
(REF. DART SPEC M304TR)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		AJS	08.03.03
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS			DART AEROSPACE LTD	
DRAWN	AJS			HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME			DRAWING NO.	REV. A
MFG. APPR.	ME			D3759	SHEET 1 OF 2
APPROVED	ME			TITLE	SCALE
DE APPR.	#			BUSHING	NTS
DATE	08.03.03			COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

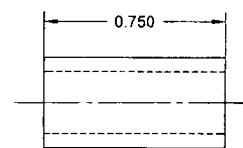
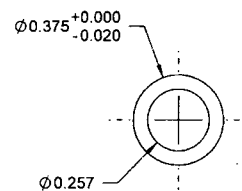
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D3759-1 BUSHING

98089

08.03.03

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	AK	D3759	SHEET 2 OF 2
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